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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

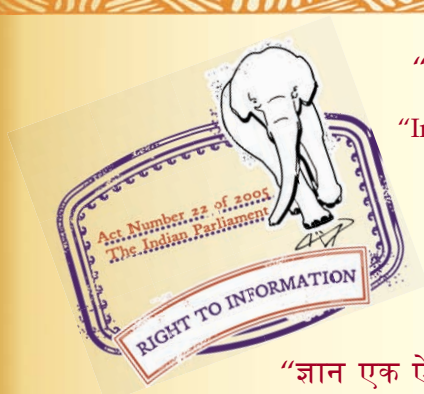
“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 9608 (1985): Specification For Gauging Members for G0 and NO G0 Screw Plug Gauges and Screw Check Plug Gauges for ISO Metric Screw Threads (Size Range Above M40 up to and Including M120) [PGD 25: Engineering Metrology]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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Indian Standard

**SPECIFICATION FOR
GAUGING MEMBERS FOR GO AND NO GO SCREW
PLUG GAUGES AND SCREW CHECK PLUG GAUGES
FOR ISO METRIC SCREW THREADS
(SIZE RANGE ABOVE M40 UP TO AND INCLUDING M120)
(First Revision)**

1. Scope — Covers the requirements for gauging members for GO and NO GO screw plug gauges for ISO metric internal threads and GO and NO GO screw check plug gauges for GO and NO GO new solid screw ring gauges in the size range above M40 up to and including M120 diameter for ISO metric screw threads according to IS : 4218 (Parts 1 to 6) 'ISO metric screw threads'.

2. Material — Shall be as prescribed in IS : 7018 (Part 1)-1983 'Technical supply conditions for gauges: Part 1 General'.

3. Dimensions — Shall be as specified in Table 1, read with Fig. 1 to 3.

4. Gauging Dimensions and Thread Profile — Shall conform to IS : 2334-1975 'Gauging practice for ISO metric screw threads (first revision)'.

5. Dirt Grooves — Dirt grooves shall be provided where necessary for GO members from 40 mm up to 120 mm. The dimensions of the dirt grooves with 'U' shape shall have width 4 mm and the depth shall be such that it clears the minor diameter of the plug gauges.

6. Designation

6.1 Gauging members for screw plug gauges shall be designated by the name of the gauging member GO or NO GO, nominal diameter, pitch, and the tolerance class according to IS : 4218 (Part 4)-1976 'ISO metric screw threads: Part 4 Tolerancing system'. If the pitch is not indicated in the designation, coarse pitch shall be implied.

Examples:

- a) A GO or NO GO gauging member of screw plug gauge of nominal diameter M60, pitch 3.0 mm and tolerance class 6H shall be designated as:

GO Gauging Member M60 × 3 — 6H IS : 9608

NO GO Gauging Member M60 × 3 — 6H IS : 9608

- b) A GO or NO GO screw check plug gauging member for new solid GO screw ring gauge of nominal diameter M60, pitch 3.0 mm and tolerance class 6 g shall be designated as:

GO Gauging Member M60 × 3 — 6 g CP for GO Ring IS : 9608

NO GO Gauging Member M60 × 3 — 6 g CP for GO Ring IS : 9608

- c) A GO or NO GO screw check plug gauging member for new solid NO GO screw ring gauge of nominal diameter M60, pitch 3.0 mm and tolerance class 6 g shall be designated as:

GO Gauging Member M60 × 3 — 6 g CP for NO GO Ring IS : 9608

NO GO Gauging Member M60 × 3 — 6 g CP for NO GO Ring IS : 9608

- d) If the dirt groove is provided for GO screw plug gauge of nominal diameter M60, pitch 3.0 mm and tolerance class 6H, shall be designated as:

GO Gauging Member M60 × 3 — 6H — DG IS : 9608

7. General Requirements — Other requirements for gauging members not covered in this standard shall conform to IS : 7018 (Part 1)-1983.

7.1 The gauge handles shall be according to IS : 5388-1983 'Hexagon handles for plug gauges, plain and threaded (second revision)'.

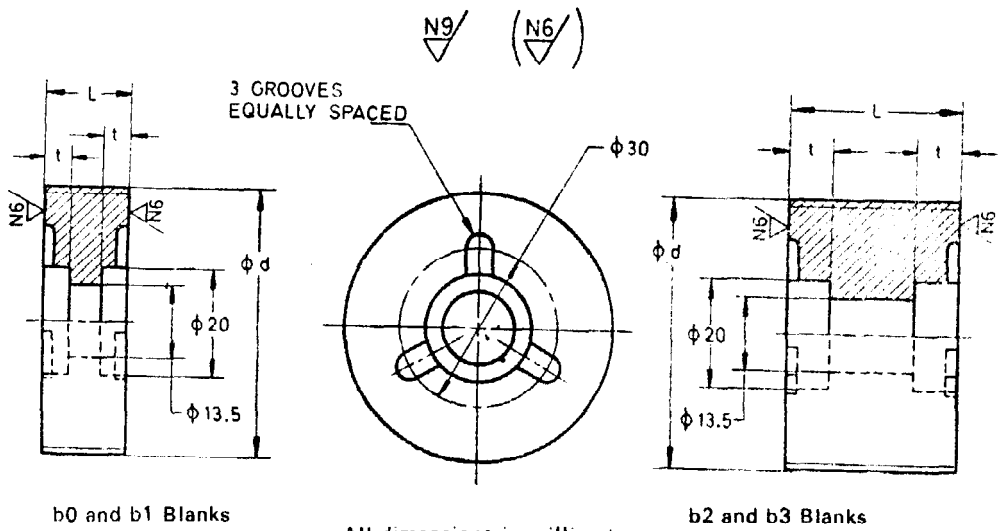
8. Marking — Shall be in conformity with IS : 7018 (Part 1)-1983.

8.1 Certification Marking — Details available with the Bureau of Indian Standards.

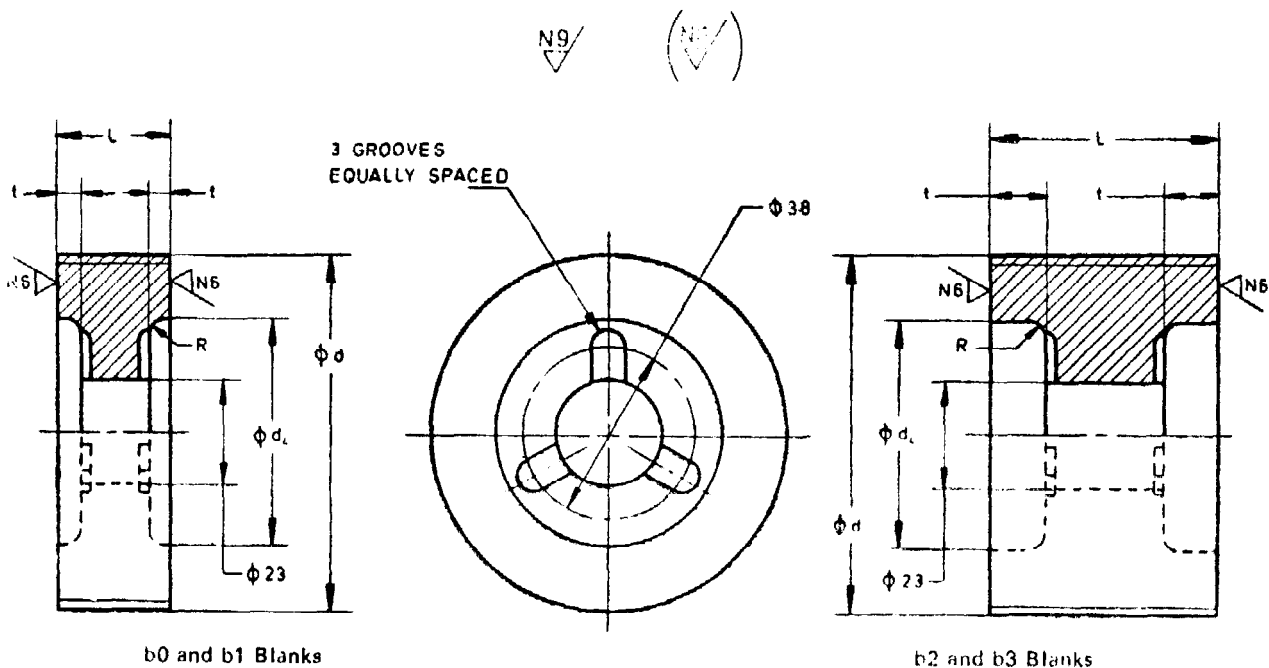
Adopted 14 May 1985

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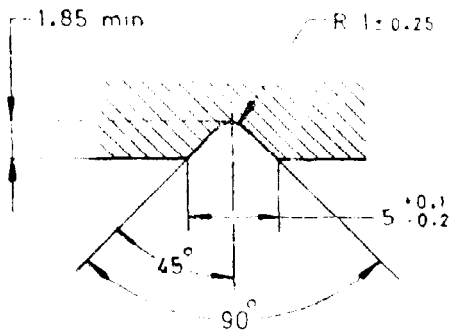
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All dimensions in millimetres.
FIG. 1 GO AND NO GO GAUGING MEMBERS
ABOVE M40 UP TO AND INCLUDING M65 DIAMETER



All dimensions in millimetres.
FIG. 2 GO AND NO GO GAUGING MEMBERS OVER M65 UP TO AND INCLUDING M120 DIAMETER
L GO — 6 pitches minimum
L NO — 4 pitches minimum



All dimensions in millimetres.
FIG. 3 DIMENSIONS OF GROOVE

**TABLE 1 DIMENSIONS FOR GO AND NO GO GAUGING MEMBERS FOR SCREW PLUG GAUGES AND SCREW CHECK PLUG GAUGES
(SIZE RANGE ABOVE M40 UP TO AND INCLUDING M120)**

(Clause 3, Fig. 1 to 3; and Explanatory Note)

All dimensions in millimetres.

Nominal Diameter <i>d</i>		Handle* No.	Recess Diameter <i>d₁</i>	R	Type b0 (Short Series)			Type b1 (Medium Series)			Type b2 (Long Series)			Type b3 (Extra Long Series)		
Above	Up to and Including				Pitches for GO Gauges	<i>L</i>	<i>t</i>	Pitches for GO Gauges	<i>L</i>	<i>t</i>	Pitches for GO Gauges	<i>L</i>	<i>t</i>	Pitches for GO Gauges	<i>L</i>	<i>t</i>
M 40	M 50	8	—	—	1.5 to 2	16	5	3	25	5	4	32	8	4.5 & 5	40	10
M 50	M 65	8	—	—	1.5 to 2	16	5	3	25	5	4	32	10	5 to 6	45	10
M 65	M 80	9 for GO 10 for NO GO	48	5	1.5 to 2	16	5	3	25	5	4	35	10	6	50	12
M 80	M 90	9 for GO 10 for NO GO	55	5	2	16	5	3	25	5	4	35	10	6	50	12
M 90	M 100	9 for GO 10 for NO GO	60	5	2	16	5	3	25	5	4	35	10	6	50	12
M 100	M 110	9 for GO 10 for NO GO	75	5	2	16	5	3	25	5	4	35	10	6	50	12
M 110	M 120	9 for GO 10 for NO GO	85	5	2	16	5	3	25	5	4	35	10	6	50	12

*IS : 5388-1983 'Hexagon handles for plug gauges, plain and threaded (second revision)'.

EXPLANATORY NOTE

This standard was first published in 1980. The first revision has been brought out to bring it in line with the latest manufacturing practices in the country and minor alterations have been made in Fig. 1 and 2 and Table 1, essentially keeping the standard based on ISO 3670-1979 'Blanks for plug gauges and handles (taper lock and trilock), and ring gauges — Design and general dimensions', published by the International Organization for Standardization.

The gauging members in this range are of trilock type. This extends the interchangeable end system to the larger size.

An additional advantage of this type of gauge is that the gauging members can be reversed when the entering end is worn out. The wedge shaped prongs on the handle are engaged with corresponding grooves in the gauging members by a single screw providing a self-centring support with a positive lock and a degree of rigidity equivalent to that of a solid gauge.

The lengths of the blanks shown in Table 1 are suitable for GO gauges of the pitches shown. If a blank is used for a finer pitch, the ends may be relieved, if the number of threads is excessive. Blanks for NO GO gauges shall be selected from the short or medium series so that there are not less than four complete threads when finished. The blank may be relieved at the ends, if necessary. Lightening holes may be provided on sizes above 100 mm.

The requirements of gauging members from M1 up to and including M40 sizes have been covered in separate specification IS : 9631-1980 'Gauging members for GO and NO GO screw plug gauges and screw check plug gauges for ISO metric screw threads (size range from M1 up to and including M40)'.